

# Work Order ID 58395

May 5, 2010 1:57:14 PM



Page 1

Item ID: D2053

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 06/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 26/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2053

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

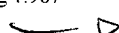
1-Cut as per Dwg D2053

Dwg Rev: S

Prog Rev: S

\*\*\*\*grain direction along 1.987" \*\*\*\*

2-Deburr if necessary



SB

10/05/09

36

B10-5-5

36

B10-5-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

QC2

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/07

36

center

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D2053 using CNC Brake

8/10/07

36

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07

center  
36

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Stop



Start Date: 06/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 26/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

⇒ m-d 4/05/07 (36x)

Hand Finishing

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

⇒ JH 10/05/10 36 Ø

Powder Coating

START TIME:

11:30AM

OVEN TEMPERATURE:

326°C

FINISH TIME:

12:00PM

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

(36) BK 10-5-10

Quality Control

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Item ID: D2053

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 06/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 26/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location: 005

0.00



Packaging

Memo

0.00

Packaging

*10/05/11 (36)*

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/05/12 HJ*  
*PS 10-5-11*  
*35*

# Picklist Print

May 5, 2010 1:57:13 PM

Page 1

Work Order ID: 58395

Parent Item: D2053

Parent Item Name: Mounting Bracket


Comments: IPP D: 02.03.18. Added Rev.B NG (Issue this IPP with part number D2052)  
IPP Rev:E now water jet 07-10-25 DD  
IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Start Date: 06/05/2010

Required Date: 26/05/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
M5052H32S.090		Purchased	No			100	sf	34.2000	0.0385	1.4		
												
5052-H32 .090 Sheet												

## Location

## Loc Qty

## Loc Code

MAT22

34.2

100782

2.2

3019

32

100782

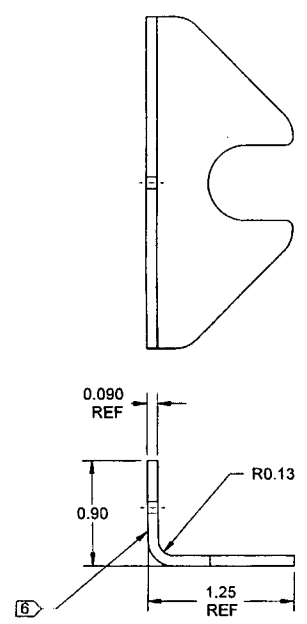
EB 10-5-5

36

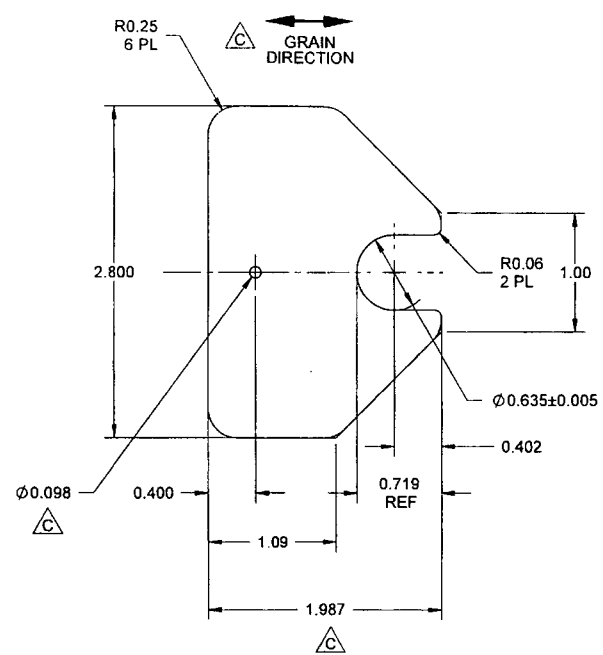


8 7 6 5 4 3 2 1

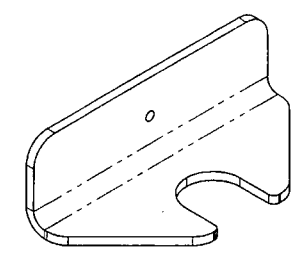
D  
C  
B  
A



**D2053 BRACKET**









**D2053F FLAT PATTERN**



*W/O 58395*

**RELEASED**  
08.05.13/PM

- NOTES:**
- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090) C
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH C
  - 7) WEIGHT: 0.04 lbs C

C	1.987 WAS 1.979 (ZN B5-1); ADD WEIGHT (ZN A8-1); ADD IDENTIFICATION (ZN A4-1); ADD Ø0.098 HOLE FOR POWDER COAT MOUNTING (ZN B6-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDTEX (ZN A6-1); ADD 6061-T6 MATERIAL OPTION (ZN A5-1); ADD GRAIN DIRECTION (ZN D5-1); QTY (2) Ø0.213 MOUNTING HOLES REMOVED; REASON: PRODUCT IMPROVEMENT			PH	08.04.25
	B	Ø0.635 WAS Ø0.437; 0.635 WAS 0.325		DS	02.03.12
A	NEW ISSUE			DS	92.01.12
REV.	DESCRIPTION			BY	DATE
DESIGN			<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN					
CHECKED			DRAWING NO.	REV. C	
MFG. APPR.			D2053	SHEET 1 OF 1	
APPROVED			TITLE	SCALE	
DE APPR.			BRACKET	NTS	
DATE	08.04.25				

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8 7 6 5 4 3 2 1